

Work Order ID 132692

132692

Page 1

Thursday, May 07, 2015 3:14:23 PM

Item ID: D4038-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle, Fwd, LH

Start Date: 5/7/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

0.00

100

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut Blank 7.125" long

P 15-05-14 3

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: E

Folio Rev: E

Deburr

P 15-05-15 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

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Thursday, May 07, 2015 3:14:23 PM

132692

Page 2

Item ID: D4038-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle, Fwd, LH
 Start Date: 5/7/2015 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

[Handwritten signature]

15-05-15

3

3

FF

DAS
44 15/05/20

3

FF

15/05/22

MAY 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Work Order ID 132692

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Revision ID:

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00			DAS				
150					30	2			MAY 25 2015
QC	Memo	0.00			9-89				
Quality Control									
160	Identify as per dwg & Stock Location: <u>G.A.</u>	0.00				3	FF		MAY 25 2015
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									15/5/27
QC	Memo	0.00							
Quality Control									

MCS MAY 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Picklist Print

Thursday, May 07, 2015 3:14:25 PM

Page 1

Work Order ID: 132692

132692

Parent Item: D4038-1

D4038-1

Parent Item Name: Angle, Fwd, LH

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased			No	100	f	54.0000	0.6	1.894737			

M6061T6A4 000W 250

**

6061T6 ANGLE 4.00 x 4.00 x .250

Location

MAT028

m118106

m128265

Loc Qty

54

34

20

Loc Code

15-05-14

1.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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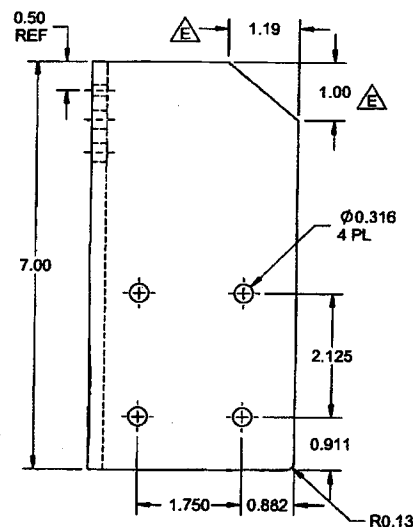
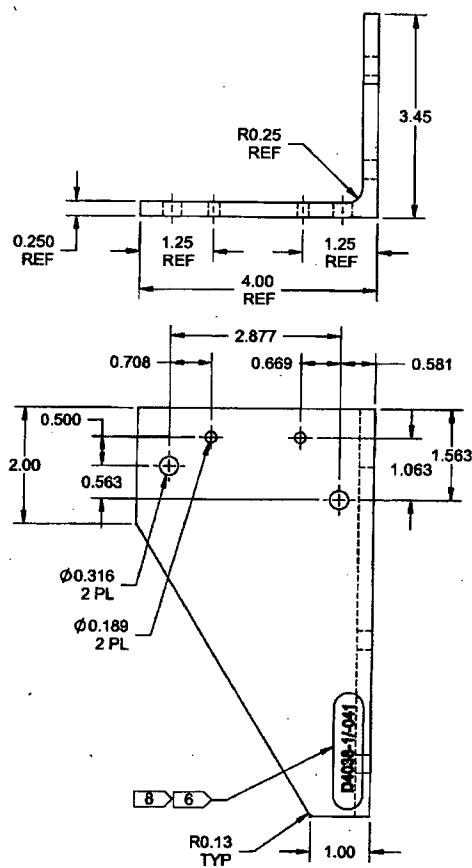
DART AEROSPACE LTD		Work Order: 132692
Description: Angle, Fwd, LH		Part Number: D4038-1
Inspection Dwg: D4038	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

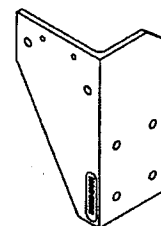
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+/-0.030	3.453	/		Vern	LPO9
1.25	+/-0.030	1.253	/			
4.00	+/-0.030	4.002	/			
1.25	+/-0.030	1.247	/			
R0.25	+/-0.030	.250	/			
0.250	+/-0.010	.246	/			
2.877	+/-0.010	2.877	/			
0.581	+/-0.010	.584	/			
0.669	+/-0.010	.669	/			
0.708	+/-0.010	.708	/			
0.500	+/-0.010	.500	/			
2.00	+/-0.030	2.015	/			
0.563	+/-0.010	.563	/			
Ø0.316	+0.006/-0.001	.317	/			
Ø0.189	+0.005/-0.001	.189	/			
R0.13	+/-0.010	.125	/			
1.00	+/-0.010	1.00	/			
1.063	+/-0.010	1.063	/			
1.563	+/-0.010	1.563	/			
0.50	+/-0.030	.500	/			
7.00	+/-0.030	7.001	/			
1.750	+/-0.010	1.751	/			
0.882	+/-0.010	.882	/			
R0.13	+/-0.030	.125	/			
0.911	+/-0.010	.910	/			
2.125	+/-0.010	2.126	/			
1.00	+/-0.030	1.00	/			
1.19	+/-0.030	1.19	/			

Measured by: D-15-05-15	Audited by: 44	Preliminary Approval:
Date:	Date: 15/05/20	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dwg Rev updated	KJ	
C	11.06.21	Dimensions updated per Dwg Rev E	KJ	



D4038-1 ANGLE, FWD, LH



- NOTES:**
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 1.03 lbs
 - 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4038	REV. E
MFG. APPR.		TITLE BRACKET	SHEET 3 OF 14
APPROVED		SCALE	NTS
DE APPR.		DATE 11.04.11	
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2011-04-21